

Date: Tuesday, 8/14/2007 6:28:53 AM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 33885		
Estimate Number	: 10227		
P.O. Number	: <i>N/A</i>	Part Number	: D2151
This Issue	: 8/14/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2151 REV B
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 28280	Material	: <i>N/A</i>
Written By	: <i>[Signature] 07-08-14</i>	Due Date	: 8/21/2007 Qty: 50 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est C 00.10.23 Re-format (mpp 2101) EC Est Rev:D 06-04-28 Manufactured on Water Jet JLM Est Rev:E 06-11-24 As per Rev B JLM		

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.0368 sf(s)/Unit Total : 1.8375 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.040" thick
(M2024T3S.040) Batch: *M103039* *18 07-08-14*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D2151
Dwg Rev: *B* *18 07-08-14*
Prog Rev: *B*

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 07/08/15 (452)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

M 07/08/20 *(XS3)*

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 33885

Part Number: D2151

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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53X

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M. A.

07/08/22

7.0	POWDER COATING	POWDER COATING
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m105068

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL

07/08/24

53

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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53X

Comment: INSPECT POWDER COAT

M. A.

07/08/25

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 17

FL

7/8/27

53

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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53

Comment: FINAL INSPECTION/W/O RELEASE

07/08/27

u 07-08-27

Job Completion

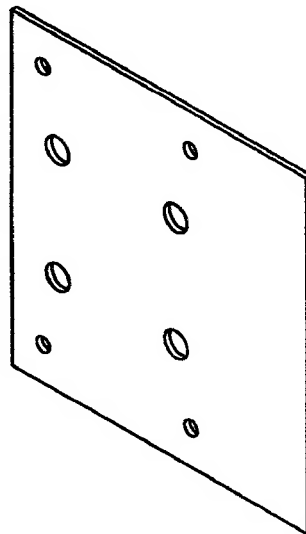
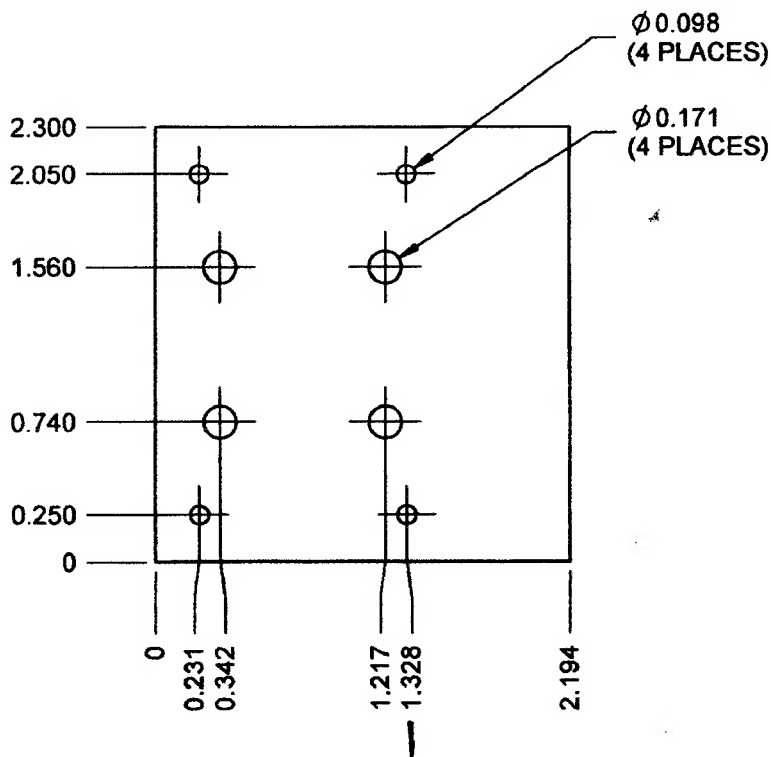




DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D2151	REV. B SHEET 1 OF 1
DATE 06.10.13		TITLE PACKER	SCALE 1:1
REV	DATE	DESCRIPTION	
A	95.05.01	NEW ISSUE	
B	06.10.13	UPDATE DRAWING	

RELEASED

06.11.20 **[Signature]**



D2151 PACKER

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D2151" USING FINE POINT PERMANENT INK MARKER

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